

Work Order ID 60991

August 3, 2010 3:09:35 PM



Page 1

Item ID:	D2842-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Assembly, 206 Float					
Start Date:	8/03/10	Start Qty:	3.00	Cust Item ID:		
Required Date:	8/12/10	Req'd Qty:	3.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	10-8-03	Tooling:		Date:		Run	Start	
	QC:	Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2842	Rev B

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut D2842-1 using D2622 extrusion as per Dwg D2842-2-Drill D2842-1 using Jig DT8271 as per Dwg D2842-3-Deburr and bevel ends for welding								

110		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

120		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld one end cap and (2) lugs using Jig DT followed by DT as per Dwg D2842-1A/R AL Rod Batch: <u>M117360</u> 2-Grind end cap weld flush								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

1. **Author(s):** _____
 2. **Title:** _____
 3. **Journal:** _____
 4. **Volume:** _____
 5. **Issue:** _____
 6. **Page(s):** _____
 7. **Year:** _____
 8. **DOI:** _____
 9. **URL:** _____
 10. **Accession Number:** _____
 11. **Keywords:** _____
 12. **Abstract:** _____
 13. **Notes:** _____
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Customer:

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC Quality Control	Memo	0.00				(7)	Pd 10.08.10		
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00				6	10/08/11		
150 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00				SAD PE	10-08-12		

Work Order ID 60991

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Page 3

Item ID: D2842-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly, 206 Float

Start Date: 8/03/10 Start Qty: 3.00



Cust Item ID:

Required Date: 8/12/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

SAD
10-08-12

④

[Signature]

170

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Remove alodine prior to welding. ☐ Weld end cap as per Dwg
D2842. ☐ A/R AL Rod Batch: M112860 ☐ 2-Grind end cap weld
flush.

10.08.12 4 *[Signature]*

180

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

④ 10.08.13

Work Order ID 60991

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Page 4

Item ID:	D2842-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Assembly, 206 Float					
Start Date:	8/03/10	Start Qty:	3.00		Cust Item ID:	
Required Date:	8/12/10	Req'd Qty:	3.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		S 10/08/12		(74) LH			
191 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo Touch up step with alodine per qsi 005 prior to powder coat	0.00 0.00		M 10/08/12		4	0		
200 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 11115281 Memo START TIME: 11:15am OVEN TEMPERATURE: 320°F FINISH TIME: 11:45am	0.00 0.00		M 10/08/12		4	0		

Work Order ID 60991

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Item ID:	D2842-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Assembly, 206 Float					
Start Date:	8/03/10	Start Qty:	3.00		Cust Item ID:	
Required Date:	8/12/10	Req'd Qty:	3.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				ml	10	08	12 (4)
220 HandFinish Hand Finishing	HandFinishing Memo 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: <u>M115028</u>	0.00 0.00				=> ml	10	08/12	xH x
230 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				8	10/08/13		(x4) LH



Work Order ID 60991

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Item ID: D2842-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly, 206 Float

Start Date: 8/03/10 Start Qty: 3.00



Cust Item ID:

Required Date: 8/12/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240



Packaging

Identify as per dwg & Stock Location: _____

0.00

PP 60990

10/8/10

(4)

Packaging

Memo

0.00

250



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

10/08/10

Memo

0.00

10/08/10

Picklist Print

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Page 1

Work Order ID: 60991

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 8/03/10

Required Date: 8/12/10

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM□□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C10L	NAS1149C0332 R	Purchased	No			100	Each	29.0000	3	9			



washer

1115000



10.08.09

Location Loc Qty Loc Code

ST245 29
107534 29

D2622-120C Manufactured No

120 Each 97.4200 1

3



Step Extrusion



10.08.09

Location Loc Qty Loc Code

WA 97.42
55214 3.42
58544 94

D2734 Manufactured No

120 Each 7.0000 2

6



Step End Plate



10.08.09

Location Loc Qty Loc Code

WA 7
55014 7

D3459-3 Manufactured No

120 Each 18.0000 2

6



Float Step Mounting Plate



10.08.09

Location Loc Qty Loc Code

WA 18
46988 1
51630 17

17

Picklist Print

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Page 2

Work Order ID: 60991

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 8/03/10

Required Date: 8/12/10

Start Qty: 3.00

Required Qty: 3.00

D3459-1 Manufactured No

220

Each

32.0000

2

6



Float Step Mounting Plate



10.08.09

Location

Loc Qty

Loc Code

WA

32

48138

10

51583

22

8

MS27039C1-07

Purchased

No

220

Each

21.0000

3

9



screw



Location

Loc Qty

Loc Code

ST293

21

11424

21

x12 10/08/12

NAS1329C3KB130

Purchased

No

220

Each

84.0000

3

9



insert



Location

Loc Qty

Loc Code

ST276

84

11981

84

x12 10/08/12

NAS1515H3L

Purchased

No

220

Each

434.0000

3

9



WASHER



Location

Loc Qty

Loc Code

FG

40

102472

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ST277

394

111819

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246

x12 10/08/12

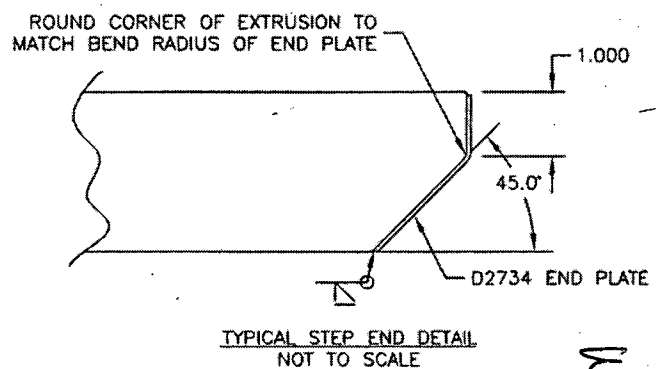
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Shop Packet Print

Page 2

DESIGN

Woburn
8-10-8-09



D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2642-041	LH STEP ASSEMBLY
	X	D2642-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

RELEASED
8-11-14

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